

Work Order ID 59871

Tuesday, June 15, 2010 1:05:20 PM

Page 1

Item ID: D2534

Accept

Revision ID:

Item Name: Lock Plate

Start Date: 6/15/2010 Start Qty: 20.00

Required Date: 6/21/2010 Req'd Qty: 20.00

Reference:

Approvals:

Process Plan: 11Date: 10-6-15

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2534

Rev D

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2734 ☐ Dwg Rev: D ☐ Prog Rev: D ☐ 2-
Deburr if necessary

304 . 125

RB 10-6-22

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

RB 10-6-22

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

8/10/06/22

Low to

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59871

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Accept

Revision ID:

Item Name: Lock Plate

Start Date: 6/15/2010 Start Qty: 20.00

Required Date: 6/21/2010 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *W/A*

0.00



Packaging

Memo

0.00

Packaging

FL 10-6-22 (L26)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/06/23 AJ**10-6-22
26*

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 15, 2010 1:05:25 PM

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Work Order ID: 59871



Parent Item: D2534

Parent Item Name: Lock Plate


Start Date: 6/15/2010

Required Date: 6/21/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-06-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 		Purchased	No			110	sf	146.8059	0.0427	0.898947	1.2		
304/316 0.125 Sheet													



1810-6-22

Location

Loc Qty

Loc Code

MAT

146.8059

114488

18.8059

114799

128

114488

60

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	59871
Description: Lock Plate		Part Number:	D2534
Inspection Dwg: D2534 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.447	+0.006/-0.001	.448	x			
R0.500	+/-0.010	.500	✓			
R0.173	+/-0.010	.173	✓			
R0.096	+/-0.010	.096	✓			
R0.125	+/-0.010	.125	✓			
R0.120	+/-0.010	.120	✓			
R0.200	+/-0.010	.200	✓			
0.125	+/-0.010	.118	✓			

Measured by:	JB	Audited by:	S	Prototype Approval:	N/A
Date:	10-6-22	Date:	10/06/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	JA

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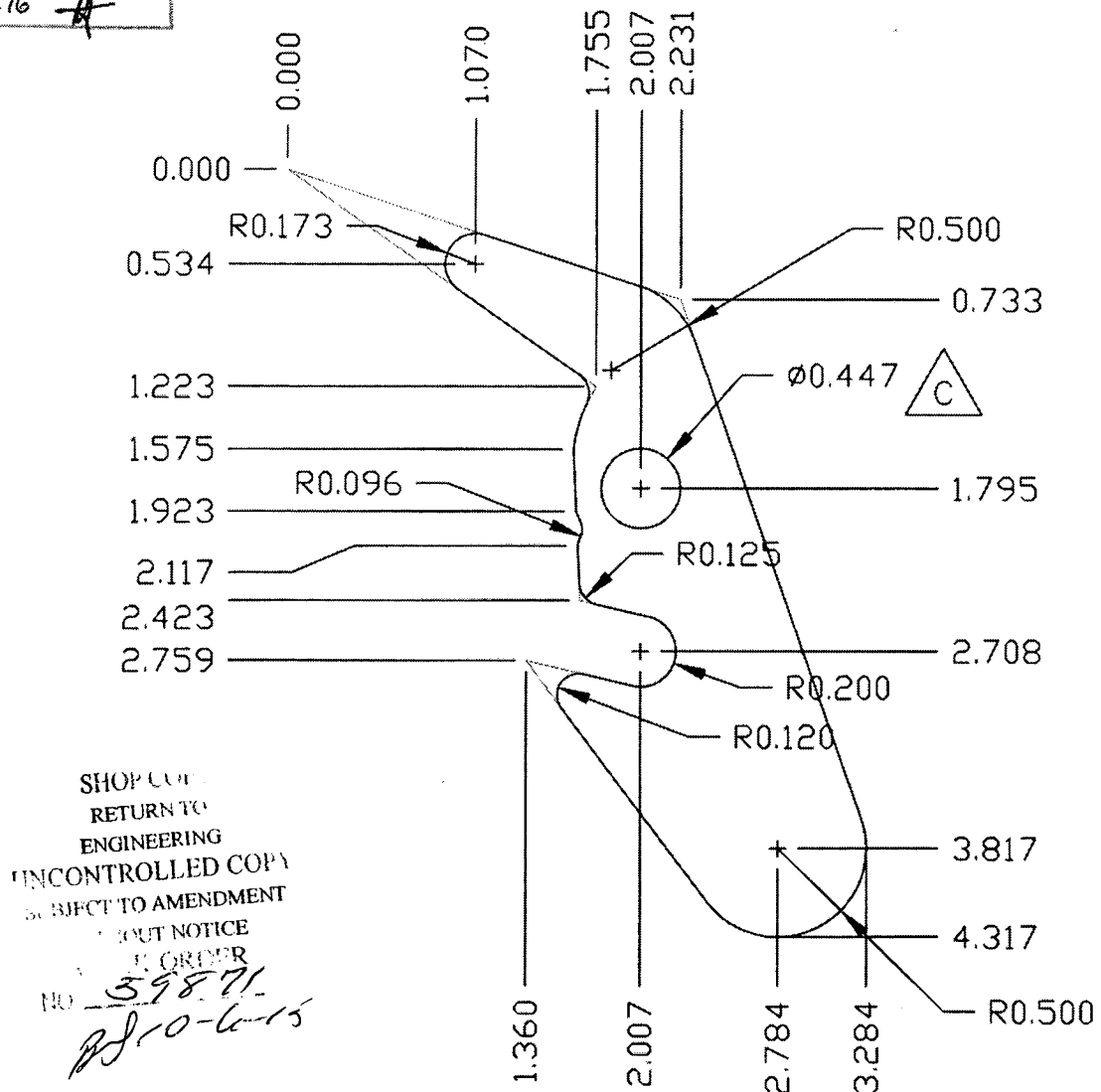
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NOTE: Date & initial all entries

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	PH	DRAWING NO. D2534	REV. D SHEET 1 OF 1
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	TITLE LOCK PLATE	SCALE 1:1
DATE 04.12.14			
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED04.12.16 *[Signature]***D2534 LOCK PLATE**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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